



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-591-311
Job Sheet 183721



Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/25/18

Job Tracking No: AIRBUS

Due Date: 12/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		12/21/18	0.00	0.00	Start Up Large Fab-4		SLU
110	Large Fab	10 pcs		12/21/18	0.00	9.91	Large Fab 2		SLU
120	QC	10 pcs		12/21/18	0.00	0.00	QC9		CPL
130	QC	10 pcs		12/21/18	0.00	0.00	QC5		CPL
140	HandFinish	10 pcs		12/21/18	0.00	1.84	HandFinish1		DR 18/10/18
150	QC	10 pcs		12/21/18	0.00	0.00	QC7-2		CPL
180	Large Fab	10 pcs		12/21/18	0.00	9.91	Large Fab 2		SLU
190	QC	10 pcs		12/21/18	0.00	0.00	QC10		CPL
200	QC	10 pcs		12/21/18	0.00	0.00	QC5		CPL
210	HandFinish	10 pcs		12/21/18	0.00	1.84	HandFinish1		DR 18/10/26
220	Powdercoat	10 pcs		12/21/18	0.00	2.90	Powdercoat1		DR 18-10-29
230	HandFinish	10 pcs		12/21/18	0.00	1.84	HandFinish3		DR 18-10-26
240	QC	10 pcs		12/21/18	0.00	0.00	QC3		NOV 01 2018 68
250	Packaging	10 pcs		12/21/18	0.00	0.00	Packaging1-3	DAS 69	NOV 06 2018 89
260	QC	10 pcs		12/21/18	0.00	0.00	QC4	DAS 69	NOV 07 2018
270	Packaging	10 pcs		12/21/18	0.00	0.00	Packaging3-1	9-89 69	NOV 07 2018
275	DC	10 pcs		12/21/18	0.00	0.00	DC	9-89 21	NOV 07 2018
280	QC21-FG	10 Ea		12/21/18	0.00	0.00	QC21	9-89	NOV 07 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M134785 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M134785 6-Grind End Plate flush 7-Install last rivet as per Dwg.

M138951 START TIME: 2:30 OVEN TEMPERATURE: 320° FINISH TIME: 3:00

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	5104284
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	5108646
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5116976

5968

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																							
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D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging
D2618	Bushing	20 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging

7XS 110 595 / 3XS 114 110
 10XS 105 216 / 10XS 101 804
 5 077 525 / 5 117 999

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	111	0
	D3219-1	20	105	0
	D3272-1	10	1	0
180-Large Fab	D3065-041	10	18	0
	D3066-1	20	130	0
	MS20600-AD4W4	160	245	0
250-Packaging	AN3-35A	20	373	0
	AN4-13A	80	774	0
	AN5-36A	20	318	0
	D2230-3	40	179	0
	D2618	20	167	0
	D2856-400-720	20	226	0
	D3235-1	20	259	0
	D3278-041	10	0	0
	MS21042L3	20	3,077	0
	MS21042L4	80	4,463	0
	MS21042L5	20	832	0
	NAS1149D0363J	40	2,097	0
	NAS1149D0463J	160	6,598	0
	NAS1149D0563J	40	1,526	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS II				Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:						MRB (QSI042) Approval							
Description Work Order Deviation								Completed By							
								Lead hand / Supervisor Approval Verification							
								QC / QA Coordinator Approval							
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; border-right: 1px solid black;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; border-right: 1px solid black;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Drill Holes ☐ </td> </tr> </table>		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Drill Holes ☐	Container No: S119272 Part: D350-591-311 Job No: 183721 Serial No/Batch: S119272 Inspector: Exp Date: Instructions: TC STC SH92-6 Issue 1d FAA STC SH967NE 04/12/21, BRAZIL 1 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com				<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; border-right: 1px solid black;"> ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence </td> <td style="width:50%;"> ☐ Misaligned/off center </td> </tr> </table>		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	☐ Misaligned/off center
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		OTHER :													



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Canada

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21 DEC
006168

D350-591-311
Job Sheet 183721



Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/25/18

Job Tracking No: AIRBUS

Due Date: 12/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

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120	QC	10 pcs		12/21/18	0.00	0.00	QC9		CPC
130	QC	10 pcs		12/21/18	0.00	0.00	QC5		CPC
140	HandFinish	10 pcs		12/21/18	0.00	1.84	HandFinish1		DR 18/10/18
150	QC	10 pcs		12/21/18	0.00	0.00	QC7-2		CPC
180	Large Fab	10 pcs		12/21/18	0.00	9.91	Large Fab 2		SLU
190	QC	10 pcs		12/21/18	0.00	0.00	QC10		CPC
200	QC	10 pcs		12/21/18	0.00	0.00	QC5		CPC
210	HandFinish	10 pcs		12/21/18	0.00	1.84	HandFinish1		CPC
220	Powdercoat	10 pcs		12/21/18	0.00	2.90	Powdercoat1		DR 18/10/18
230	HandFinish	10 pcs		12/21/18	0.00	1.84	HandFinish3		BEB 18-10-29
240	QC	10 pcs		12/21/18	0.00	0.00	QC3		
250	Packaging	10 pcs		12/21/18	0.00	0.00	Packaging1-3		OCT 31 2018
260	QC	10 pcs		12/21/18	0.00	0.00	QC4		
270	Packaging	10 pcs		12/21/18	0.00	0.00	Packaging3-1		
275	DC	10 pcs		12/21/18	0.00	0.00	DC		
280	QC21-FG	10 Ea		12/21/18	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M134785 3-Grind End Plate flush
180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M134785 6-Grind End Plate flush 7-Install last rivet as per Dwg.
413895.1 220 - START TIME: 2:30 OVEN TEMPERATURE: 320° FINISH TIME: 3:00
270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084
275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	5104284
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	5106446
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5106476

5968

D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging
D2618	Bushing	20 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging

7XS 110595/3X S1
 10XS 105216/10XS 10
 5077525/S 117
 5101329
 5115326
 5099504
 5117629
 518035
 5104554
 5113205
 5114310
 5094592
 5094592
 5093592
 5045293
 5092780
 5050052

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	111	0
	D3219-1	20	105	0
	D3272-1	10	1	0
180-Large Fab	D3065-041	10	18	0
	D3066-1	20	130	0
	MS20600-AD4W4	160	245	0
250-Packaging	AN3-35A	20	373	0
	AN4-13A	80	774	0
	AN5-36A	20	318	0
	D2230-3	40	179	0
	D2618	20	167	0
	D2856-400-720	20	226	0
	D3235-1	20	259	0
	D3278-041	10	0	0
	MS21042L3	20	3,077	0
	MS21042L4	80	4,463	0
	MS21042L5	20	832	0
	NAS1149D0363J	40	2,097	0
	NAS1149D0463J	160	6,598	0
	NAS1149D0563J	40	1,526	0

Part Specifications

Specifications could not be found.

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

REFERENCE ONLY

REFERENCE ONLY

REFERENCE ONLY

REFERENCE ONLY

Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]

